Work Ord August-01-13 1		5352	,	*1(15352*							Page 1
Item ID: Revision ID:	647.5701		A	Accept	*N90	00040	100)* s	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	GPS MOUNT 8/01/13 : 8/01/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust It Custon					Stop	^N:	S2*
Approvals:	Process Plan	n: <u>Mし</u> づ	Date: 13-08-01	Tooling: SPC (Y/N):		Date:		I	Run	Start Stop		R1* R2*
Sequence ID/ Work Center I	D /	Operation Description		Set Up/ Run Hou	Tool	ID Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr 647,2600 51	(AM)	ision Nbr										PG
*10 /	-	Pick Kit		0.00	DAS 27			12				
Packaging Packaging		Memo		0.00	15 10 A	1						<u> </u>
•												
*110 *110* QC Quality Control		QC4- 100% Inspect kits Memo	for completeness	0.00				12-	• -			\$30 (3-c
120		Identify as per dwg & St	ock Location:	0.00	DAS 27			Þ				
120 Packaging Packaging		Memo Identify and	package as per mpp-120	0.00	27 9-89 13 10-04			. 1	<u>.</u> .			
φ*.		PHCKI	161NG!		,			12		S	L E	3-10-2

											DQA:	Date:	
NCR:	⁄es	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPI				•
·											QA Closed:	Date:	,
Work Orde	or.	104	ے جسے	- 7.		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					··	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.	/10	47.	570	5/	Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•		. / /	5 / C	<u> </u>	Use-as-is			noforming	Finishing		re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier	1
	•								- <u> </u>		•		
Root					Descri	ption of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш				6	1011	1					į	
Equip/Tooling		الام			Docu,	ment (ontrol					,		
Operator		1, 10,7	เค		,,,,,							5	
Material		75.	10"		Platac	sou blue file + type				7		DAS 16	DAS
Setup					11110 9	200 - Lun 570+	Ļ	-				9-89	16 9-89
Other					labels P	neg 111 641.51					1.1		
Process					2	6-61 CCK					IAX	13/11/11	13/11/11
Supplier					Z						1210.24		ויוויולי
Training					(2)		١				19,10.		
Unapproved				<u> </u>									
						F	AUL	T CATE	GORY				
Landi	ng (Gear			_	General		-			1	_	-
	_	Pate Step Qty Company Company				Bend	<u> </u>	Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	$ldsymbol{le}}}}}}}$	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	-, ^T	Cracks				Broken/Damaged	<u></u>	Inspecti	ion Incomplete	<u></u>	Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	<u> </u>	Part Moved		
		Heat Trea	it			Countersink		Mislabe	eled		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Ore	·	•		*105		Pag					
Item ID: Revision ID:	647.5701			Accept	*N900	040	100)* 9	Setup Start	*N	S1*
Item Name:	GPS MOUN	T							Stop	*N	S2*
Start Date:	8/01/13	Start Qty: 12.00	*12*		Cust Item I	D:					
Required Dat	e: 8/01/13	Req'd Qty: 12.00	*12*		Customer:						
Reference:			• •							•	
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:		I	Run Start	*N	R1*
••	QC:		Date:	SPC (Y/N):	Date:				Stop	*N	R2*
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

130

Quality Control

130

QC21- Final Inspection - Work Order Release

Memo

13-10-31 WF 10-31

Page 2

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP		QA Closed:	Date:	•
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N		· .			Rework Scrap	1 1	Skid-tube Machining	Crosstube Small Fab	i e	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Use-as-is Work Order Update	Inem	noforming Large Fab	Finishing Composite	Rec/Sto	Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data				•							
Equip/Tooling											
Operator	.,										
Material [
Setup											
Other											
Process		1			•						

Landing Gear General Bend Ovalized Pressure/Forced Bending Grain BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Part Moved Contamination Maintenance Mislabeled Positioned Wrong Heat Treat Countersink Misread Power Loss/Surge Other Inspection Strip in Tube **Cut Too Short** Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

FAULT CATEGORY

Supplier Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print August-01-13 11:24:13 AM Work Order ID: 105352 Parent Item: 647.5701 Parent Item Name: GPS MOUNT Comments: IPP REV:A N Component Item ID/ Replacement Item Name DAS Item ID G47:57102 GPS MOUNT M527039:08-14 Screw DAS

August-01-13 11:24:13 AM

Work Order ID: 105352

Start Date: 8/01/13

Required Date: 8/01/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

IPP REV:A NEW ISSUE 13-07-15 JLM VERIFIED BY:DD

Comments:		IFF KEV.F	I NEW 13	SSUE 13-07-13 31											
Component Item Item Name	ID/ DAS	Replace Item ID		Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.5710 GPS MOUNT	27 9-89	1279		Manufactured	No				Each	0.0000	11	05420		3	
MS27039-08-14 Screw		240		Purchased	No				Each	105.0000	/3	24			DAS
, cicw		DAS 27 9-89	1200			Location		Loc Qty	<u>La</u>	oc Code			33 200	3 °	
							2019 26474	105 5 100			5 + 11	2019 26474			S as
AS1149FN832P				Purchased	No	mi	2014.1	100	Each	15,536.000		48	94 33 8)	34.
VasiiCi						Location		Loc Qty	Lo	oc Code			6 889 C C		•
DAS	6	\triangleright				ST294		5560			·				
27 9-89						12:	3522	400 5160							₄ nAS
3 33						ST510a	J J 0.4.9	9976			12	3900			6
							5268	9976							9.89
1521042-08 ISE MS21042L08				Purchased	No				Each	870.0000	29	24	0A - 33 - 33)	13-09
DAS	12	\sim				Location		Loc Qty	L	oc Code			& 80°		
27	10					ST314	_	770			V —				
9-89							35257	770			12	3525			
						ST315	3352	100 100			_ / 0	J <u>2</u> 2 <u>2</u> 2			
647.57.U SHIM				Manufactured	No	12.	5532	100	Each	0.0000 \DAS	~ h/	12)4493		0	13-09-
DA 27 9-8	S 7 89	300								\ 9 8			- 40		·

NCR:	Yes / No	WORK ORDER NON-CONFORM
WCIV.	163 / 110	Work Orbert Hort Cold Child

DQA:	Date:	

NCR: Y	es/	/ No				WORK ORDER NON-	COP	VFORI	MANCE / UP	DATE			
											QA Closed:	Dat	e:
Work Orde	er: _					DISPOSITION	,		cid and a	AGAINST DE	PARTMENT,	/PROCESS Water Jet	T Facilitation [T]
Part N	_				<u>-</u>	Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing		d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No					Work Order Update	╛┃		Large Fab	Composite		Supplier	
Root		_				ption of work order update		nitial		tion	Sign &	., .,	
Cause	\dashv	Date ^	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling		٠, ١											
Operator	Н	-4											
Material	H												
Setup	Н												
Other	Н												
Process	H												
Supplier	П						ļ						
Training	П												
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng G	ear				General		_			_	_	
ł		Bending				Bend		Grain			Ovalized	Ţ	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	_BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong _	
		Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	'Surge	Other
		Ripples ir	n Bend			Drill Holes		Offset					
		Torque M	Vaves in 1	Extrusio	on _	Drawing		Out of	Calibration				
	\Box	Turning S	Sequence	:		Finish		Out of	Sequence				
	Wayo/Twist in Tubo			ho		Teolio		Outcide	Dimonsions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

NOTES:

MATERIAL: 6061-T6 ALUMINUM PER AMS-QQ-A-200/8

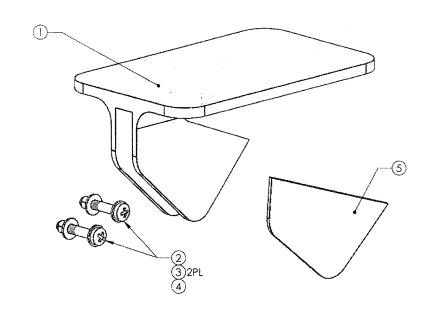
finish: Hard anodize IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK: CARDINAL 4860-50 PRETREATMENT PRIMER; PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX

MATERIAL: LAMINATED ALUMINUM 1100 ALLOY SHIM STOCK LAYER THICKNESS: .003"
FINISH: NONE VENDOR: MCMASTER-CARR P/N 9574K68

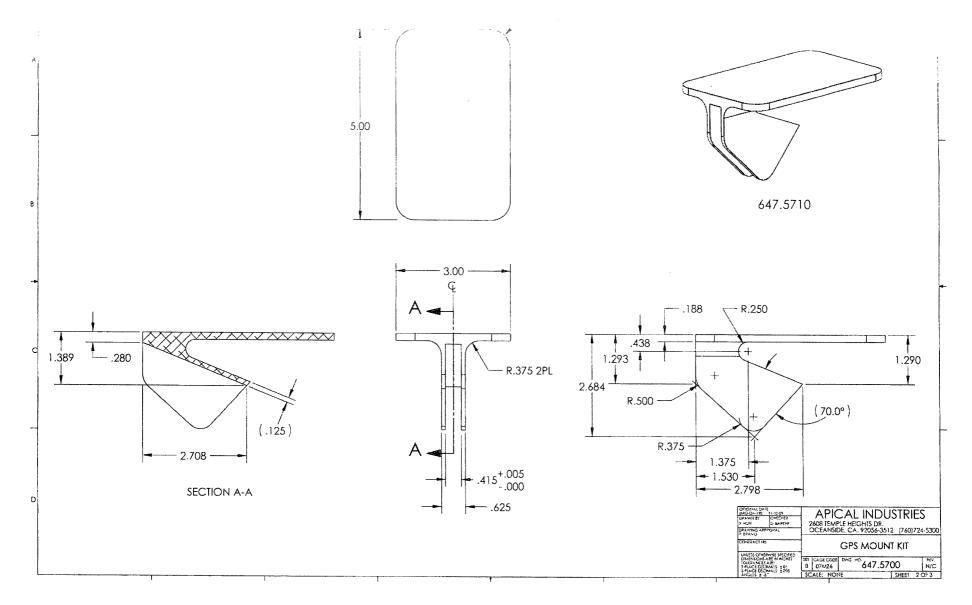
- 4. DEBURR AND BREAK ALL SHARP EDGES
- 5. IDENTIFY IAW MPP-120

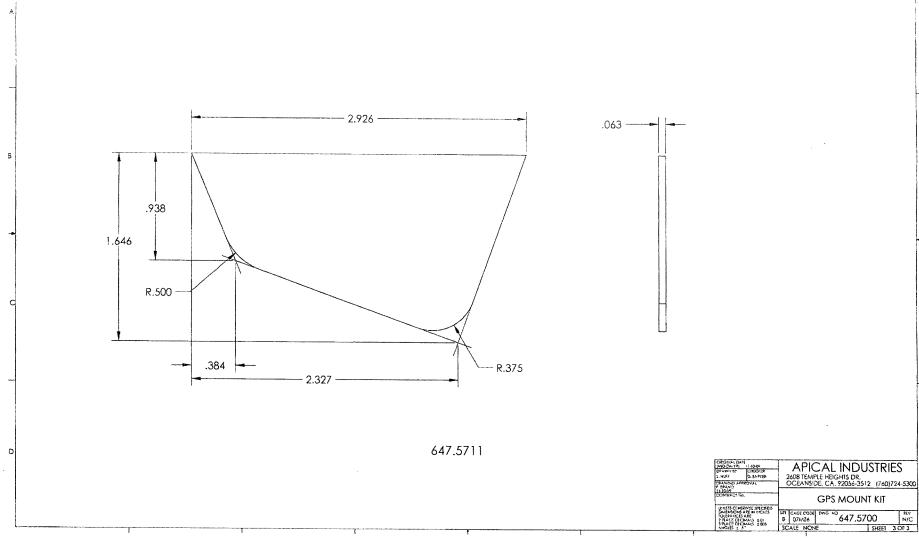
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	1	5	647.5711	SHIN	Λ .		A	1		
	2	4	601.2973		KNUT		MS21042-65			
	4	3	601.2764	WA	SHER	·na	NA31149594833	,		
	2	2	601.3081	SCR	EW		A4\$27039-063	4		
	1	1	647.5710	GPS	MOUNT		Δ		Δ	
	\supset		647.5701	GPS	MOUNT K	IT				
	,5791	FIND #	PART#		DESCRIPTI	ON	MAT'L		SPEC	
QT	<u> </u>				PARTS LIST					
NEXT	ASSY (S)	DRAW S Hui	TELY CHECKEN		2608 TEMP	LE HEIG	INDUS HTS DR. 92056-3512			
		- dish	SLOIMENVEE SPICE			GPS .	MOUNT	KII		
			NSONG ARE IN INCHES RANCES ARE ICE DECEMALS ±01 ICE DECEMALS ±015	· [53	1.07.14.4		647.570			N/C.
		ANG	d\$ 1.5°	18	CALE NON	E	i.	SHEET	10	<i>i</i> 3



647.5701 GPS MOUNT KIT





Work Orde	er ID 105352 1:24:13 AM		*105	352*						•	Page 1
Revision ID: Item Name:	647.5701 GPS MOUNT		Accept	*N900	<u>040</u>	100	*	Setup S	Start Stop		S1*
Start Date: Required Date: Reference:	8/01/13 Start Qty: 12.00 8/01/13 Req'd Qty: 12.00	*12* *12*	·	Cust Item l Customer:							
Approvals:	Process Plan:QC:		Tooling: SPC (Y/N):		ate:		I	Run S	start Stop		R1* R2*
Sequence ID/ Work Center ID			Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty		Reject Number	Insp. Stamp
Draw Nbr 647,2600 570	Revision Nbr		,			The state of the s			# Nervice was a second of the		
100 *100* Packaging Packaging	Pick Kit Memo		0.00			_		ИС		13-10	-24
110	QC4-100% Inspect kits	for completeness	0.00								
110 QC Quality Control	Мето	co competitives	0.00			_	12	-	e distribution of the second		23th 13-
•											
20 *120*	Identify as per dwg & Sto	ock Location:	0.00								
Packaging Packaging	Memo Identify and	package as per mpp-120	0.00					***************************************			-